












Date: Monday, 20/04/2009 1:00:06 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 47296		
Estimate Number	: 10425		
P.O. Number	:	Part Number	: D32191
This Issue	: 20/04/2009 S.O. No. :	Drawing Number	: D3219 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 45397	Material	:
Written By	:	Due Date	: 27/04/2009 Qty: 120 Um: Each
Checked & Approved By	: <u>JUL 09.04.20</u>		
Comment	: Est. A04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S125	6061-T6 .125 Sheet	
		8.	
Comment: Qty.: 0.1012 sf(s)/Unit Total : 12.1464 sf(s) 6061-T6 .125 Sheet To be made in multiples of <u>2</u> Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: <u>110062</u> <u>B9-5-5</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>B9-5-5</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>B9-5-5</u>	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>8 02/05/05</u> <u>counter</u> <u>(144)</u>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary. 2- buff water jet marks inside only <u>M-L</u> <u>09/05/07</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3219-1 PAR #: N/A Fault Category: Prod/FAB ASS'y ^{mat & smd} NCR: (Yes) No DQA: D Date: 09/05/11
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/05/11

NCR: <u>47296</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>9/5/11</u>	<u>50</u>	<u>6 Parts Found at deburring with a Round side from Deburring machine Edge is thin. OBS'd R.C. Process.</u>	<u>[Signature]</u>	<u>Scrap qty 6 no replace</u>	<u>[Signature]</u> <u>9-5-11</u>	<u>[Signature]</u> <u>09/05/11</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>09/05/11</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 47296

Part Number: D32191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/08

138

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: PAT

9/5/08

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/11

Job Completion



MF 09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47296
Description: Plate		Part Number: D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	.318	*			
2.293	+/-0.005	2.295	*			
2.965	+/-0.010	2.964	*			
0.566	+/-0.010	.567	*			
0.375	+/-0.010	.375	*			
R0.125	+/-0.010	.125	*			
13.9°	+/-0.5°		*			

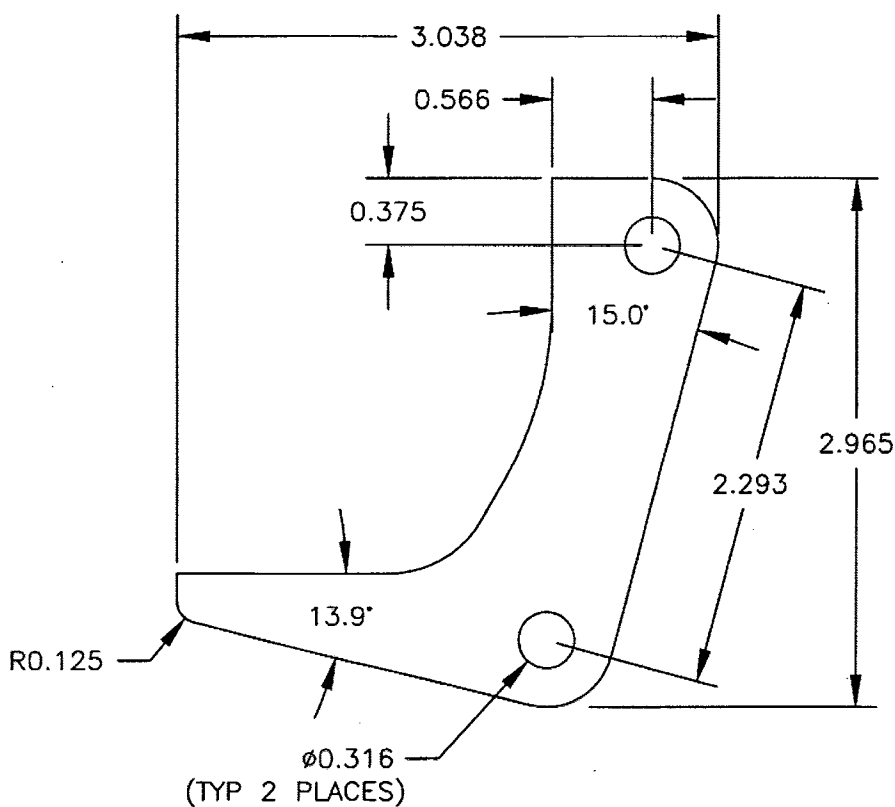
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-5	Date: 09/05/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	
C	08.04.15	0.125 dimension removed	KJ/DD	



DESIGN <i>ip</i>	DRAWN BY <i>ip</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04 04 05



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPR1"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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